

Date: Friday, 30/05/2008 10:13:14 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: INNER AFT SADDLE		
Job Number	: 39606			Part Number	: D5957		
Estimate Number	: 11082			Drawing Number	: D5957.REVB		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/05/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 15/06/2008 Qty: 6 Um: Each		
Previous Run	: 39510						
Written By	:						
Checked & Approved By	: <u>JUL 08.5.30</u>						
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	Saddle Billet
 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) <input checked="" type="checkbox"/> D6101-007(7075-T7351) <input checked="" type="checkbox"/> Size 2.50" x 7.50" X 8.25" (Grain along 7.50") <input checked="" type="checkbox"/> Batch: <u>B34873</u> <u>DIP 08/06/03</u>		
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
 <b>Comment:</b> HAAS CNC VERTICAL MACHINING #3		
1-Machine as per folio D5957, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble		
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
 <b>Comment:</b> INSPECT ALL DIM TO DIM SHEET <u>DIP 08/06/04</u> / <u>18 08/06/05</u> (6)		
4.0	QC8	SECOND CHECK
 <b>Comment:</b> SECOND CHECK <u>JL 08/06/05</u> (6)		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
 <b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>20/8/05</u> / <u>08/06/05</u> (6)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:15 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39606

Part Number: D5957

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107925



6X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

220

FINISH TIME:

9:30

m-1

08/06/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/09

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 421

AS 08/06/09 X6

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 X7

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



c 08/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	39606
Description: Inner Aft Saddle			Part Number:	D5957
Inspection Dwg: D5957 Rev: B			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.442	.441	.441	.441		
B	1.745	1.755		1.748	1.744	1.744	1.748		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.001	7.001	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.750	4.7485	4.7485		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.525	1.526	1.527	1.527		
I	3.048	3.058		3.052	3.054	3.053	3.053		
J	4.575	4.585		4.580	4.579	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.500	0.500	0.501		
N	1.865	1.885		1.879	1.879	1.878	1.875		
O	7.990	8.010		8.000	8.007	8.000	8.000		
P	2.240	2.260		2.240	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		0.494	.500	.500	.500		
T	1.625	1.645		1.6385	1.6375	1.639	1.639		
U	2.000	2.020		2.003	2.003	2.004	2.004		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>-DJP</i>	<i>89</i>	Audited by:	<i>JL</i>
Date:	<i>08/06/04</i>	<i>08/06/05</i>	Date:	<i>08/06/05</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD <i>OK</i>	<i>DS</i>

DART AEROSPACE LTD			Work Order:	39604
Description: Inner Aft Saddle			Part Number:	D5957
Inspection Dwg: D5957			Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

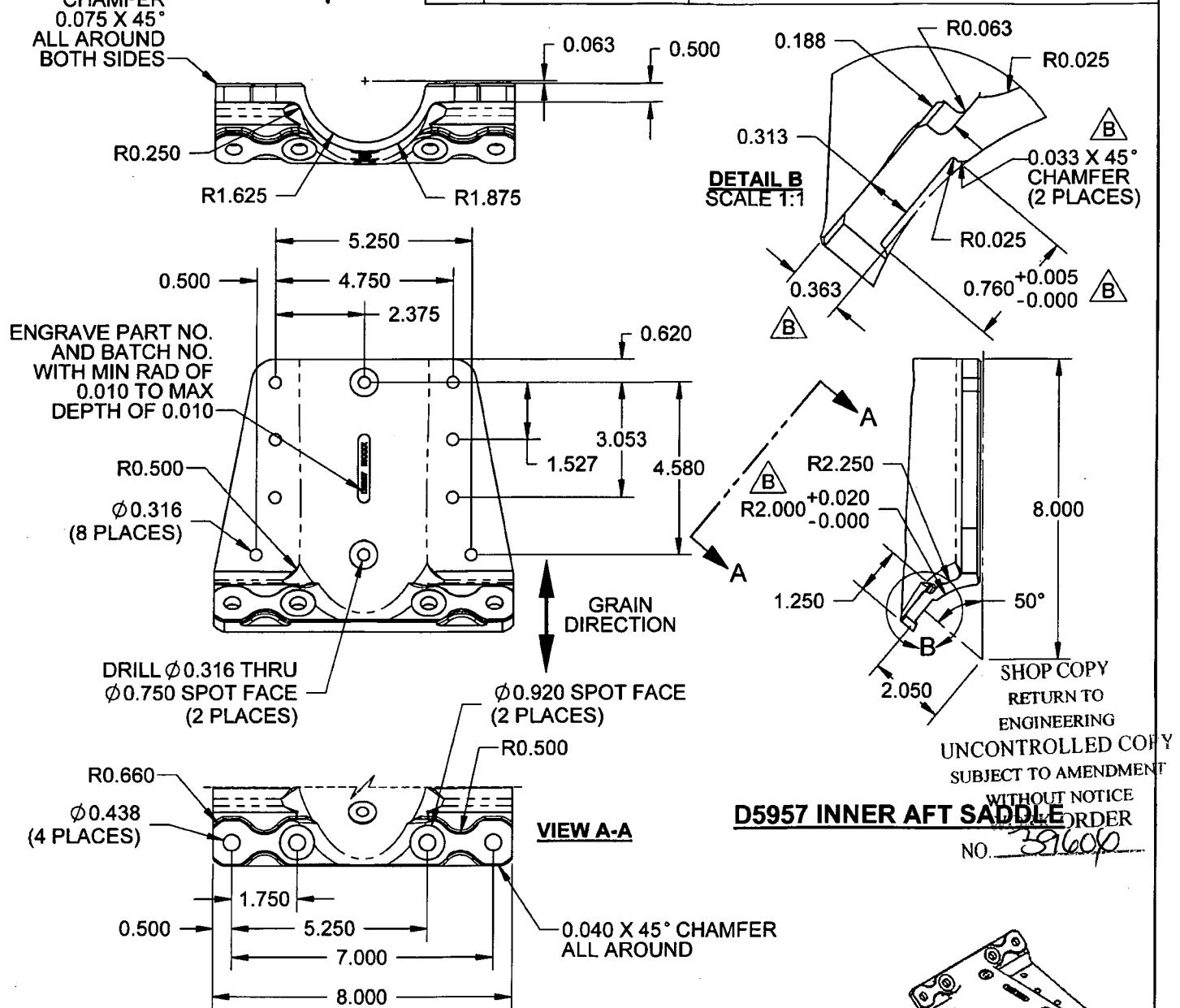
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				5	6	3	4			
A	0.438	0.443		.441	.441					
B	1.745	1.755		1.750	1.750					
C	5.245	5.255		5.250	5.250					
D	6.995	7.005		7.000	7.000					
E	5.240	5.260		5.250	5.250					
F	4.745	4.755		4.749	4.750					
G	0.315	0.322		0.322	.321					
H	1.522	1.532		1.527	1.527					
I	3.048	3.058		3.054	3.054					
J	4.575	4.585		4.580	4.580					
K	0.313	0.318		0.318	.318					
L	0.495	0.505		0.500	.500					
M	0.490	0.510		0.505	.500					
N	1.865	1.885		1.880	1.875					
O	7.990	8.010		7.999	7.995					
P	2.240	2.260		2.250	2.250					
Q	0.307	0.312		.310	.310					
R	0.760	0.765		.760	.760					
S	0.490	0.510		.500	.500					
T	1.625	1.645		1.631	1.635					
U	2.000	2.020		2.010	2.007					
V	0.023	0.043		.033	.033					
W										
X										
Y										
Z										
AA										
AB										
AC										
AD										
AE										
AF										
Accept/Reject										

Measured by:	<i>SP</i>	Audited by:	<i>JL</i>
Date:	<i>08/05/05</i>	Date:	<i>08/06/05</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD <i>SP</i>	<i>DS</i>

## **DART**

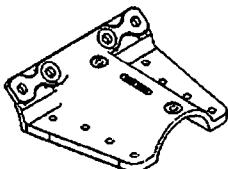
DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. <b>D5957</b>	REV. B	SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>		SCALE <b>1:4</b>	
REV	DATE	DESCRIPTION		
A	<b>97.05.06</b>	NEW ISSUE		
B	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM		



**NOTES:**

**NOTE:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 **B**
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



**ISOMETRIC VIEW**  
SCALE 1:8